

Date: Thursday, 10/08/2006 10:02:17 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ASPIRATOR
Job Number	: 28138	Part Number	: D2061
Estimate Number	: 11968	Drawing Number	: D2061 REV. A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 10/08/2006	S.O. No.	: N/A
Prsh Rev.	: NC	Type	: PURCHASED PARTS
First Issue	: N/A	Material	: N/A
Previous Run	: N/A	Due Date	: 05/09/2006
Written By			
Checked & Approved By			
Comment	: Est: B 01.12.17 Added step 3, 4 and Inspection Level 21. SM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
		Comment: PURCHASING Issue P/O: 1809 Make per Dwg D2061 Possible Supplier: Sieg's Manufacturing Material release note required <i>C206108110 (25)</i>
2.0	D2061P	Aspirator 
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 25.0000 Each(s) ASPIRATOR BODY
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <i>PJ 6/9/01 (25)</i>
4.0	QC6	DIMENSIONAL CHECK  <i>J060915 25</i>
		Comment: DIMENSIONAL CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr and clean to remove was residue <i>FF 06.09.10 25</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/07/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ASPIRATOR

Job Number: 28138

Part Number: D2061

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Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB

06/09/20

25

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: C2A

SB

06/09/20

55

8.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21



25

SB 06/09/20

Job Completion



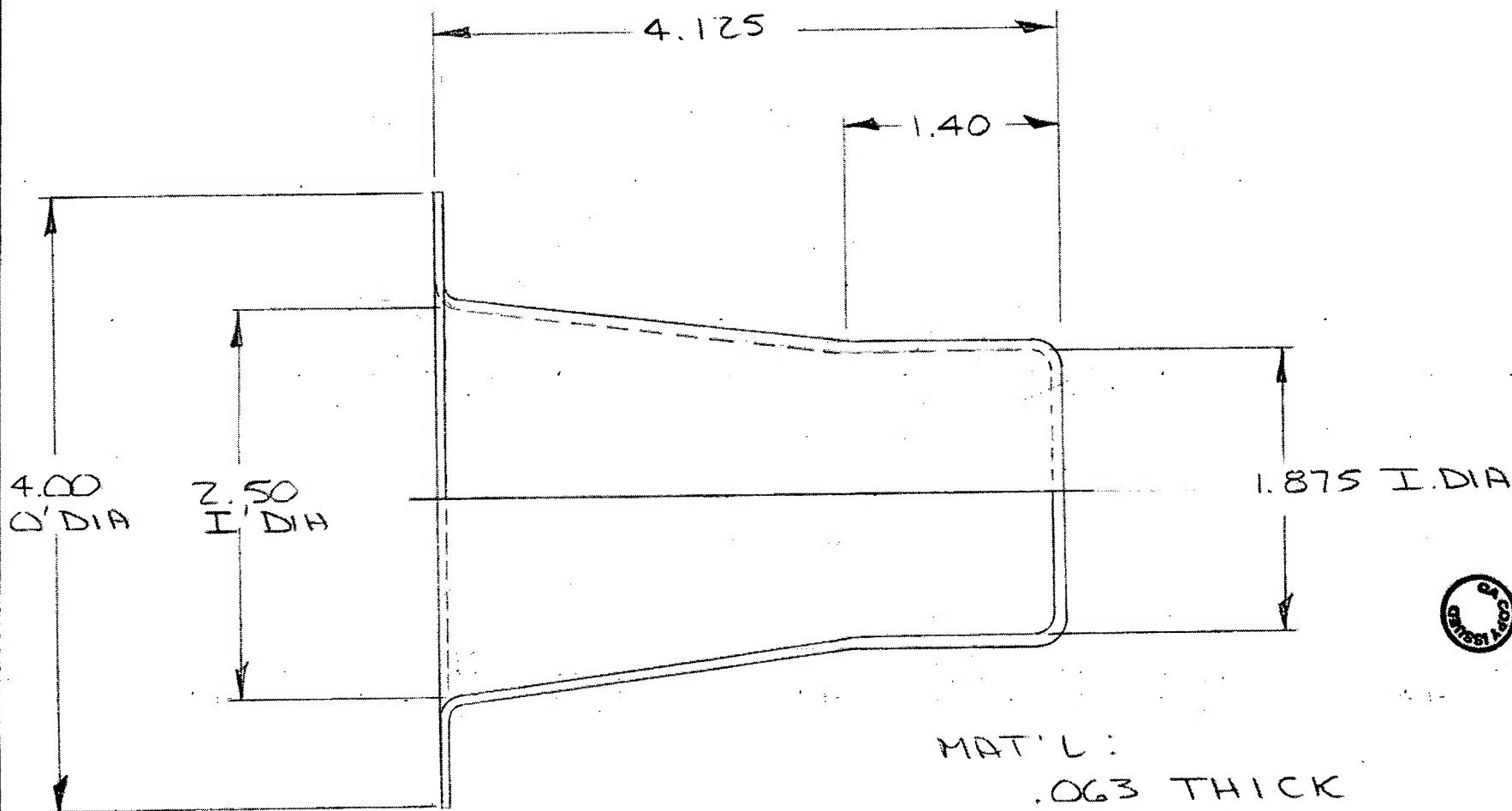
U 06/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MAT'L:

.063 THICK  
1100 ALUMINUM

	REVISION				RIVET CODE SHALL BE PER NAS 523	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR	
	DRAWN	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.			BASIC CODE	DIA. DASH NO. R-HEAD REAR SIDE F-HEAD FAR SIDE	CONTRACT NO.	<p style="text-align: center;"><b>DART</b></p> <p>VANCOUVER CANADA</p> <p><b>ASPIRATOR BODY</b></p> <p>YSD Z061</p>			
	APPROVED				D-DIMPLE DIGITING OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DRAWN				DATE
<b>DESCRIPTION OF CHANGE</b>	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED			BASIC CODES	DESIGN	BRADLEY					
	GENERAL		LIMITS			10-2A					
	1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHNESS . <sup>000</sup> <sub>000</sub> 3. REMOVE SHARP EDGES . <sup>015</sup> <sub>015</sub> MAX 4. THREADS PER INL . <sup>2742</sup> <sub>2742</sub> 5. HOLES PER INL 10387		1. TOLERANCES — . <sup>.001</sup> <sub>.000</sub> X . <sup>.010</sup> <sub>.010</sub> 2. ANGLES — . <sup>8°</sup> <sub>8°</sub> 3. PARALLELISM — . <sup>.0025</sup> <sub>.0025</sub> 4. ECCENTRICITY — . <sup>.005</sup> <sub>.005</sub> MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES . <sup>.005</sup> <sub>.005</sub>		STRESS						
	REPORT ALL DISCREPANCIES — DO NOT SCALE					CHECKED					
						CLIENT					
					SCALE	1 : 1	SET	1 OF 1			

**sm**

Sieg's Manufacturing Ltd.

*604 530-7455 fax 604 530-7490  
6236-205 Street, Langley, British Columbia. Canada. V2Y 1N7*

## **INSPECTION REPORT**

DATE: Aug. 25/06

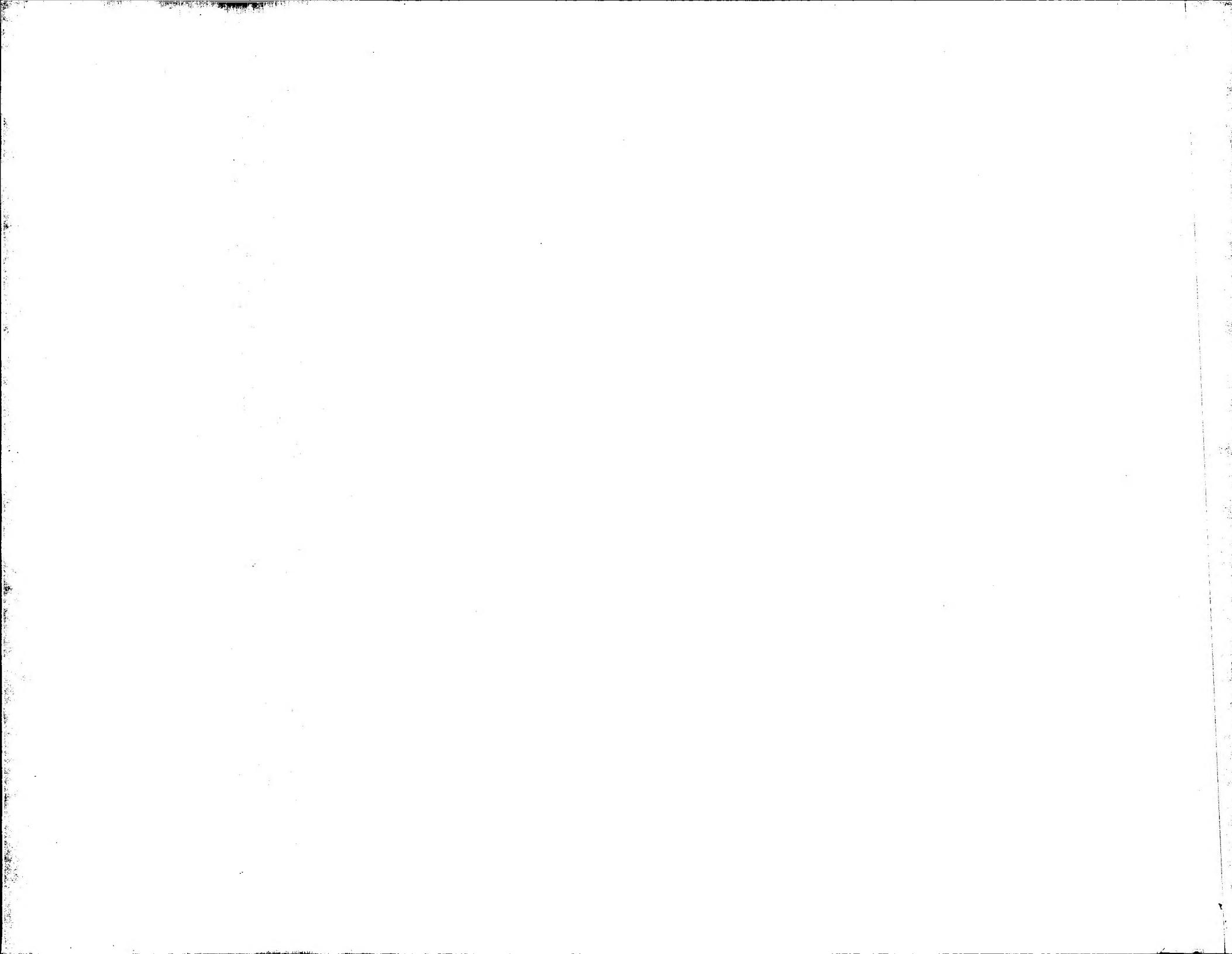
**CUSTOMER:** Dart Aerospace

**INVOICE #:** \_\_\_\_\_ **SUPPLIER #:** \_\_\_\_\_

**DESCRIPTION OF INSPECTION:**

**NOTES OF INSPECTION:** Good

**NOTES OF REJECT:**



**ALUMAX**  
MILL PRODUCTS, INC.  
1480 Mainline Pike, Lancaster Pa. 17601

**SOLD TO:**  
KEN-MAC METALS INC  
2 THYSSEN DRIVE  
DETROIT, MI 48210

## Certification of Test Results

TO BE ADVISED  
PA

SHIP TO:  
PO 811326

ORDER NO	055535	PO NO	71993-D
ITEM NO	1	PART NO	
ALLOY	1100	TEMPER	O
GAUGE	.06360	WIDTH	46.0000

FORM COIL  
LENGTH .0000

MILL FINISH  
NON ANODIZE QUALITY  
OUT: STANDARD MILL FINISH  
IN: STANDARD MILL FINISH  
NOT EMBOSSED

LOT: 004297 COIL: B01

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*EG25571	0.12	0.47	0.13	0.003	0.008	0.000	0.003	0.002	0.01

HEAD ULTIMATE STRENGTH 13.8 KSI  
TAIL ULTIMATE STRENGTH 13.9 KSI  
HEAD YIELD STRENGTH 5.5 KSI  
TAIL YIELD STRENGTH 5.2 KSI  
HEAD ELONGATION 30.5 %  
TAIL ELONGATION 30.5 %

\* AS REPORTED BY SUPPLIER  
MECHANICAL PROPERTIES ACCORDING TO ASTM B557

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:  
QQA 250/1P 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT  
\*\* END OF CERTIFICATION \*\*

BE REPRODUCED EXCEPT IN FULL

Date 12-11-98  
Cust. CUSP Mfg Inc  
W/O # 4423487  
Qty. 500 Pcs.  
These test reports are for material shipped  
on your PO# 2145  
From Copper & Brass Sales Inc.  
Quality Representative  
Customer Part #

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alumax sales order agreement.

Authorized By:

RON GANTZ